Dart Aerospace Ltd. Monday, 3/17/2008 11:56:54 AM Date User: Kim Johnston **Process Sheet Drawing Name** : MOUNTING ANGLE Customer : CU-DAR001 Dart Helicopters Services Job Number : 38026 : 10509 **Estimate Number** : D2564 Part Number P.O. Number : D2564 REV. B1 : 3/17/2008 S.O. No. : **Drawing Number** This Issue : N/A Prsht Rev. : NC Project Number : 11 : MACHINED PARTS : B1 First Issue Type **Drawing Revision** : 36533 Previous Run Material Due Date : 4/10/2008 Qty: 50 Um: Written By Checked & Approved By : Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF Comment Additional Product Job Number: Seq. #: Machine Or Operation: Description: 1.0 D6207 Angle Extrusion 1x1x.125 Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s) Angle Extrusion Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8) Batch: B37670 (D6207) BAND SAW BAND SAW 2.0 Comment: BAND SAW Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030) 3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1 Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA276 Rev: A & Dwg D2564 Rev:

2-Deburr if necessary

4.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

SECOND CHECK

Comment: SECOND CHECK

Each

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			·	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
48												
Part No	-	PAR #:	Fault Categ	ory:	NC	R: Yes	No DQ/	\:	Date:			
3						QA: N	/C Closed	d:	_ Date: _			
NCR:			WORK ORDE	R NON-CONFORM	IANCE	(NCR	(1)					
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval			
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector		
							-					
		3										
		G.			*							

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 11:56:54 AM Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: MOUNTING ANGLE Job Number: 38026 Part Number: D2564 Job Number: Seq. #: Description: **Machine Or Operation:** PACKAGING 1 PACKAGING RESOURCE #1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 7.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE m= 08-03-28 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP		PF	ROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		1	÷								
4											
		ŧ									
Part No	<u> </u>	P <i>i</i>	AR #:	Fault Category:	NC	R: Yes	No DO	A:	Date:		
									Date:		
NCR:				WORK ORDER NON-CON	FORMANCI	E (NC	R)				
DATE	CTED	Description	of NC	Corrective Actio	n Section B		Verifi	cation	Approval	Approval	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval			
DATE	STEP	Section A		Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector				
							*				
					-						
		1									
							*				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38026
Description: Mounting Angle	Part Number:	D2564
Inspection Dwg: D2564 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST **First Article Prototype** Drawing Actual Method of Tolerance Accept Reject Comments Inspection Dimension **Dimension** 1.00 +/-0.030 1.014 0.625 +/-0.010 Ø0.257 +/-0.010 1.000 +/-0.010 +/-0.010 1.000 R0.375 +/-0.010 Measured by: Audited by: **Prototype Approval:** N/A N/A

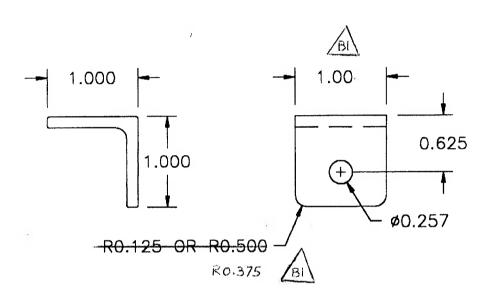
Rev	Date	Change			Revised by	Approx/ed
A 0.	4.06.10	New Issue	1, -11	•	KJ/JLM ox	9//





	DESIGN DRAWN BY MIKE M MIKE M CHECKED APPROVED			DART AEROSPACE LTD
			MIKE M	VICTORIA INTERNATIONAL AIRPORT, CANADA
			APPROVED_	DRAWING NO. REV. B
	B	ک	BW	D2564 SHEET 1 OF 1
	DATE 96:04:30		L	TITLE SCALE
				MOUNTING ANGLE 1:1
	В		97:05:06	MODIFIED DIMENSIONS
	BI A RT 02.09.17		02.09.17	RO.375 WAS RO.125 OR RO.500 .
				1,00 WAS 1,000

RELEASED



NOTES

i) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125

MAKE FROM DE207-XXX ANGLE EXTRUSION

- 2) BREAK ALL SHARP EDGES 0.005 0.015
- 3) TOLERANCES PER DART ESI DIS UNLESS OTHERWISE NOTEDSHOP COPY
- 4) ALL DIMENSIONS ARE IN INCHES

RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

NO. 38036